

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000413**Date Inspected:** 29-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**Witness:** Procedure Qualification Record  
Welding NDT**Welder Qualification** **Fracture Critical**  
**Mechanical Testing, describe:** Fillet Marco etch**Index Lot #:** B75-055-07**Witness Lot #:** B22-027-07**Bridge No:** 34-0006**Component:** Bid: 52**Welder:** Jiang Xian Hu**ID #:** N/A**Joint Description:** "T" FILLET

N/A

**WPS ID #:** PWPS-B-T-3111

N/A

**Base Metal:** ASTM A709M-HPS-485T2/Z

N/A

**PQR ID #:** HP2007251

N/A

**Thickness:** 90mm

N/A

**Process:** SMAW

N/A

**Electrode Spec/Class:** AWS A5.5

N/A

**Positions:** 1F

N/A

**Backing Material:** N/A

N/A

**CWI:** Huang Wei

N/A

**Average Amps:** 166.8

N/A

**AWS Code:** D1.5-2002

N/A

**Average Volts:** 22.8

N/A

**Applicable Sec:** 5.13

N/A

**Travel Speed:** 80.6

N/A

**Heat Input:** 2.83

N/A

**Preheat:** 172°C

N/A

**Summary of Items Observed:**

Quality Assurance (QA) Inspector Brannon was present as requested to witness the welding of the mechanical test for Procedure Qualification record (PQR) test plate using shielded metal arc welding (SMAW) 5.0mm diameter electrode in the 1F (flat) position. Test was performed per the AWS D1.5, Section 5.20 requirements. The test results appeared to be in compliance with contract documents.

**Summary of Conversations:**

No significant conversations on this date.

**Observed welding, testing or results:**

is in general conformance with the contract requirements.

is not in conformance with the contract requirements.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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# WELDING WITNESS REPORT

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<b>Inspected By:</b>	Brannon, Sherri	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar, Robert	QA Reviewer

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